Ship Monday 24/03

Rev 5 DAS 16 14/03/26

~~PRELIMINARY ISSUE~~

Work Order ID 115219

115219

March-18-14 11:40:55 AM

D4541-5
B115219

Item ID: D4541-5
Revision ID:
Item Name: Bracket, LH
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-03-19 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	DAS 27 9-89	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4541 Revision Nbr: P E2		Rev E								
100		DAS 10 9-89	0.00							
100							8	14/03/24		mm/E
Waterjet	**Memo**		0.00							
FLOW CNC Waterjet	1- Cut as per dwg D4541-5F Prog rev: D4541 Dwg rev: PE2 2- Deburr									
110	QC2- Inspect parts off machine FAI/FAIB		0.00							
110							8	14/03/24		mm/E
QC	**Memo**		0.00							
Quality Control										

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115219

March-18-14 11:40:55 AM

115219

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Revision ID:
Item Name: Bracket, LH
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Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89				8			
120		0.00 14/3/25							
QC	**Memo**					Inspect as per Dwg - PED			
Quality Control									
125		0.00							
125					DAS 30 9-89	8			14/03/25
Small Fab	**Memo**	0.00							
Small Fab	BEND TABS PER DWG								
127	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
127						(B) 14.03.26			
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
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General

☐ Bend
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☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
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☐ Drawing
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☐ Hardware
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☐ Instructions Incomplete/Unclear
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☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115219

March-18-14 11:40:55 AM

115219

Item ID: D4541-5
Revision ID:
Item Name: Bracket, LH
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
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Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
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Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				8	14-3-26		
	Memo	0.00							
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00 DAS 27 9-89 14/3/26				8			
	Memo	0.00				Inspect as per Dwg PE2			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST525	0.00				8 DAS 28 9-89		MAR 26 2014	
	Memo	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
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☐ Drawing
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☐ Grain
☐ Hardware
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☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D4541-5
Revision ID:
Item Name: Bracket, LH
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Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLS 14-03-26

MF 14-3-26

POSITIVE RECALL
EFFECTIVE 4.03.19 AUTH
RELEASED DAS 16 9-89 DATE 14/3/26

Release Dwg & Rev E DAS 27 9-89 14/3/26

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Positioned Wrong
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

March-18-14 11:40:59 AM

Work Order ID: 115219 *115219*

Parent Item: D4541-5 *D4541-5*

Parent Item Name: Bracket, LH

Start Date: 3/18/14 **Required Date:** 4/01/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	410.6032	0.204	2			
M6061T6S.032									**		mm	14/03/24	
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code	
MAT021	410.60317		
123483	8.57		
m125822	17		
m127272	128.75317		
m128054	256.28		2.3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

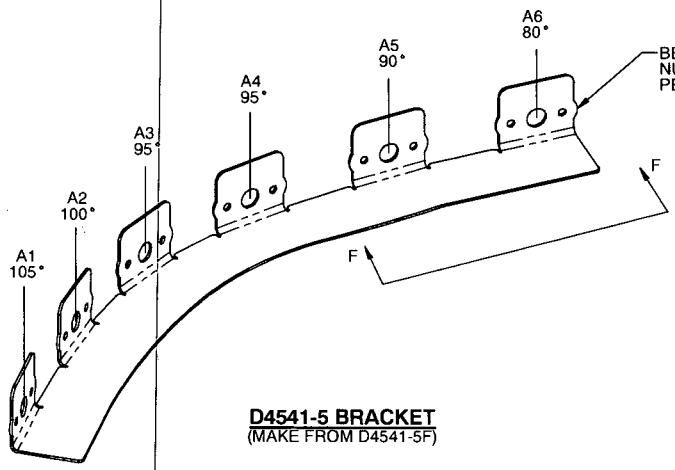
FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

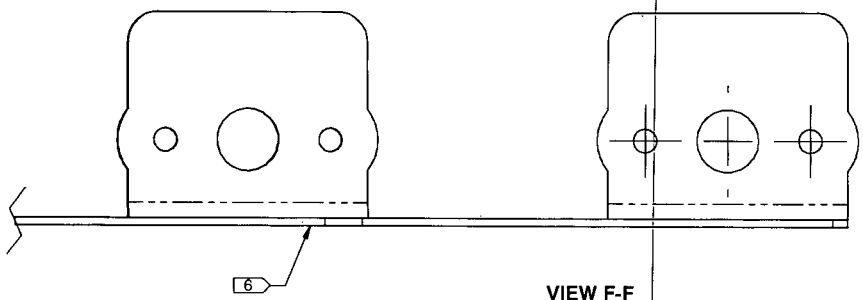
☐ Bend
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☐ Contamination
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



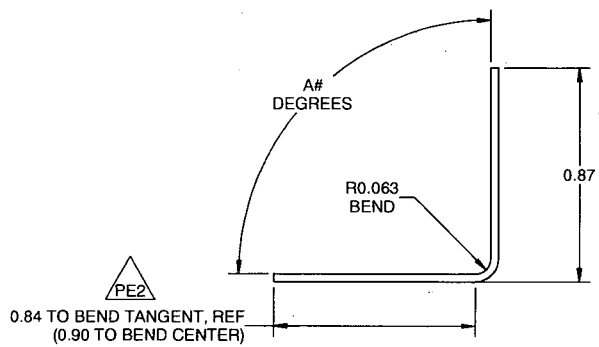
BEND EACH TAB THE INDICATED NUMBER OF DEGREES PER VIEW F-F

D4541-5 BRACKET
(MAKE FROM D4541-5F)

MD 115219



VIEW F-F
BEND DETAIL
SCALE 2X

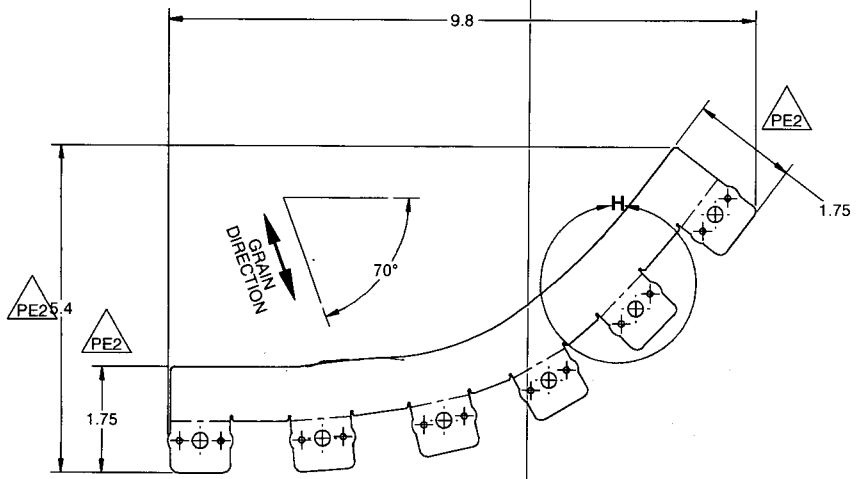


PRELIMINARY E2
14.03.07 (AJS)

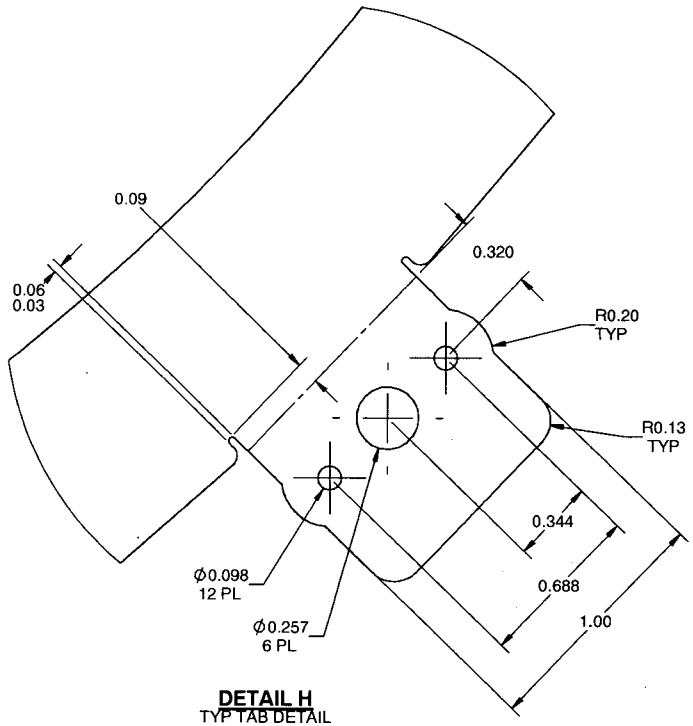
NOTES:
1) MATERIAL: MAKE FROM D4541-5F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE2
MFG. APPR.		D4541	SHEET 8 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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D4541-5F FLAT PATTERN



DETAIL H
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.04 ibs
8) PROFILE PER DRAWING FILE "D4541-5F-REVE.DXF"

PRELIMINARY E2
14.03.07 (AJS)

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4541 — REV. PE2
MFG. APPR.		SHEET 10 OF 13
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE	14.03.07	

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DART AEROSPACE LTD	Work Order:	115219
Description: BRACKET LH	Part Number:	D4541-5
Inspection Dwg: D4541 Rev: DEZ		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.8	+/-0.100"	9.8	✓	V	Jkm-05	
Ø.0257	+0.006 -0.001	0.0260	✓	V	Jkm-07	
Ø.098	+0.004 -0.001	1.01	✓	V		
1.00	+/-0.030	0.991	✓	V		
0.688	+/-0.010"	0.684	✓	V		
0.344	"	0.348	✓	V		
0.320	"	0.320	✓	V		
1.75	+/-0.030"	1.75	✓	V		
5.4	+/-0.100"	5.4	✓	V		
			DAS 27			

Measured by:	JM 14-03-25 AMM/EL
Date:	14/03/24

Audited by:	9-89
Date:	14/3/25

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

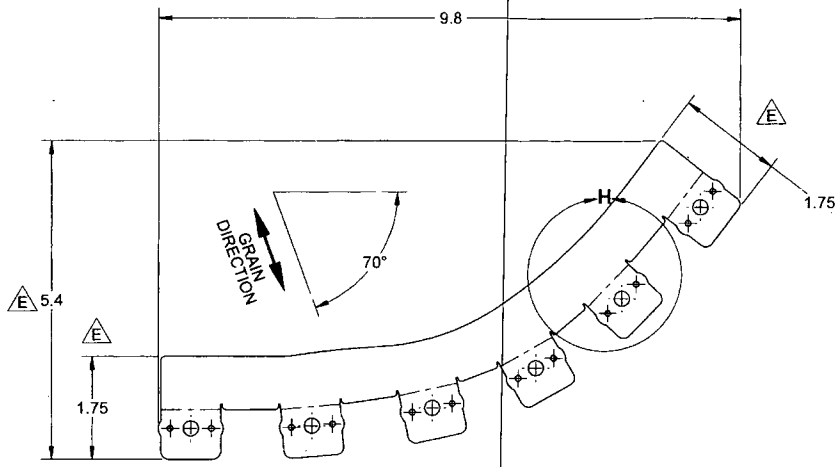
DART AEROSPACE LTD

Description:	Bracket LH	Work Order:	115219
Inspection Drawing:	D4541	Rev: PE2	Part Number: D4541-5

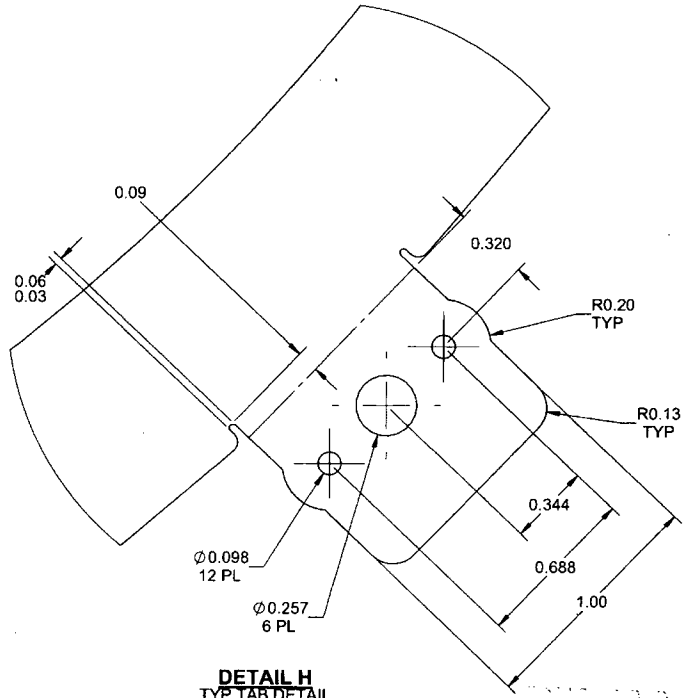
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.87	+/- .030	.878	✓		V	S-1
.84	+/- .030	.845	✓		V	S-11
80°	+/- 1/2°	80°	✓		Protector	S-7
90°	+/- 1/2°	90°	✓		"	S-7
95°	+/- 1/2°	95°	✓		"	S-7
100°	+/- 1/2°	100°	✓		"	S-7
105°	+/- 1/2°	105°	✓		"	S-7

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessa*
DAS 30 9-89	DAS 36 9-89		
Date 14/03/25	Date 14/03/25	Date	Date



D4541-5F FLAT PATTERN

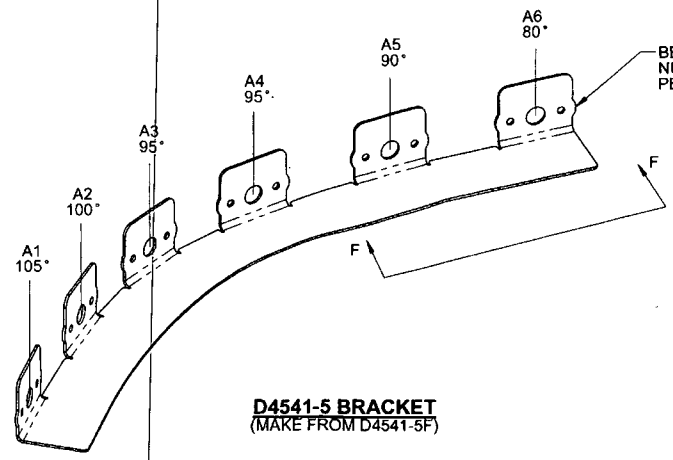


DETAIL H
TYP TAB DETAIL
SCALE 4X

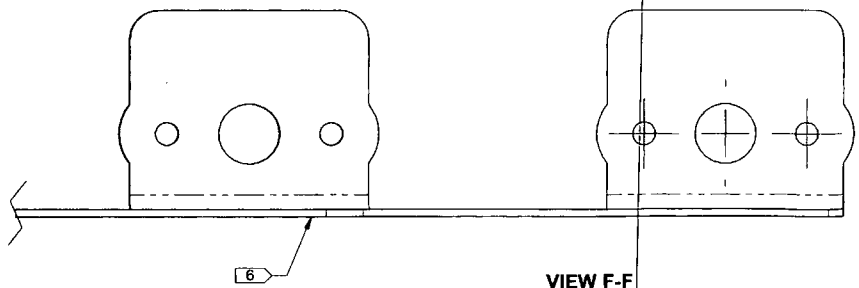
NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.04 lbs
8) PROFILE PER DRAWING FILE "D4541-5F-REVE.DXF"

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 10 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

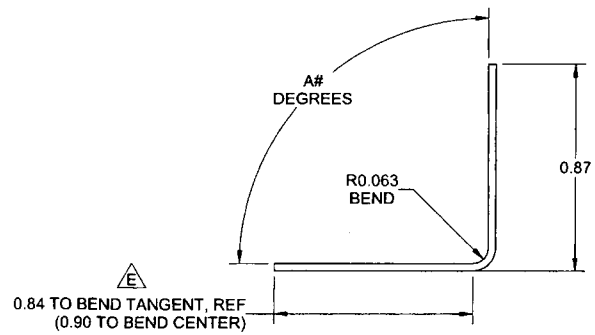
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D4541-5 BRACKET
(MAKE FROM D4541-5F)



VIEW F-F
BEND DETAIL
SCALE 2X



RELEASED
2014-03-26

NOTES:
1) MATERIAL: MAKE FROM D4541-5F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D4541 SHEET 8 OF 13
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
DATE	14.03.07	

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